

G64102-30

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

DD FORM

proof of purchase



owner registration sticker



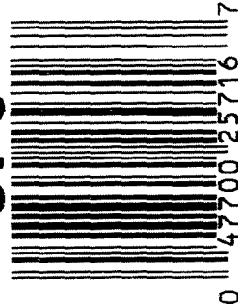
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6410230

UPC



ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYST

UPC



0 47700 25716 7

ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYST

UPC



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SERIAL NO.



66410230

10/26/2004 7:51:17 AM

Original

7

Original

25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)



.MA25716

Shop Order: SWS10-15-5



.ABSWS10-15-5

Start Date: 9/20/2004

Finish Date: 10/15/2004

0540

Flat Black Powder Coat, Barrel and

01PC001



0003512703

0560

Reassemble Action.

89SWS1



0003512704

0690

Pack Rifle

89SWS1



0003512697

0700

Stencil SWS Container

89SWS1



.OP0700

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6410230

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		8-24-04	RTL
600	PROOF		8-24-04	RTL
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	8-24-04	RTL
610	DIS-ASSEMBLE GUN	AUG 25 2004	8-24-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR 		
615	ROLLMARK CALIBER		8/25/04	L
617	DRILL AND TAP SIGHT HOLES		8-24-04	TRW
620	APPLY COATINGS (BARREL ACTION)		9/7	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-23-04	Rev
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-23-04	Rev
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-23-04	Rev
	D) OIL FIRING PIN ASSEMBLY		9-23-04	Rev
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.9</u> <u>4.5</u> <u>4.5</u>	10-12-04	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.9</u>	10-12-04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		10-12-04	RL
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.020</u> <u>.020</u>	10-12-04	DA
	J) ASSEMBLE STOCK		9-23-04	RL
	K) ASSEMBLE SWIVEL STUDS		10-12-04	RL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-23-04	RL
	M) IRON SIGHT ALIGNMENT		9-23-04	RL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-23-04	RL
640	GALLERY TEST AND TARGET	PASS FAIL	10-4-04	TRW
	MALFUNCTION <u>FPO</u>	CORRECTION <u>PASS</u>	10-11-04	AC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		10-4-04	TRW
655	FINAL INSPECTION A) HEADSPACE		10-12-04	RL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.80</u> <u>2.80</u> <u>2.74</u> <u>2.67</u> <u>2.76</u>	10-12-04	DA
	C) FUNCTION		10-12-04	RL
660	PACK		10/23/04	DA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)
3.00 LBS (plus or minus 0.75 LBS)
4.00 LBS (plus or minus 1.00 LBS)

SERIAL NO. _____

DATE 6-21-04

TESTER RW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.64	2.67		2.36	
PULL #2	2.64	2.65		2.33	
PULL #3	2.56	2.60		2.37	
PULL #4	2.67	2.71		2.34	
PULL #5	2.74	2.71		2.39	
TOTAL	13.25	13.34		11.79	
AVERAGE	2.65	2.67		2.36	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.27		
PULL #2	3.34	3.03		
PULL #3	3.23	3.08		
PULL #4	3.34	3.11		
PULL #5	3.17	3.01		
TOTAL	16.23	15.50		
AVERAGE	3.25	3.10		

	4.00 LBS INITIAL	4.00 LBS AFTER 20 CYCLES	MAX SETTING GREATER THAN 4 LBS	RESET TO 4 LBS FOR TARGET & ACCURACY
PULL #1	4.38	4.15		4.07
PULL #2	4.12	3.99		4.06
PULL #3	4.11	3.98		4.08
PULL #4	4.10	4.01		4.07
PULL #5	4.06	4.06		4.06
TOTAL	20.77	20.19		20.34
AVERAGE	4.15	4.04		4.07

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410230.___0

FILE DATE AND TIME: 10/04/2004 08:08

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.032
The Average Y Centroid of the Five Target Set:	-0.087
The Average Point of Impact of the Five Target Set:	0.093
The Average Mean Radius of the Five Target Set:	0.874
The Distance from POA to Centroid Target #1:	0.318
The Distance from Centroid Target #2 to Centroid Target #1:	0.541
The Distance from Centroid Target #3 to Centroid Target #1:	0.327
The Distance from Centroid Target #4 to Centroid Target #1:	0.566
The Distance from Centroid Target #5 to Centroid Target #1:	0.717

SERIAL NUMBER: G6410230. __0

TARGET NUMBER: 1

FILE DATE: 10/04/2004

FILE TIME: 08:08

POINT#	X	Y
1:	0.685	0.217
2:	0.605	0.654
3:	-0.099	0.417
4:	-0.252	0.804
5:	-0.467	0.255
6:	-0.346	-0.282
7:	-0.889	1.656
8:	0.288	-0.040
9:	0.241	-0.205
10:	-0.018	-0.306

X CENTROID: -0.025

Y CENTROID: 0.317

POA TO CENTROID: 0.318

HORZ SPREAD: 1.574

VERT SPREAD: 1.962

GROUP SPREAD: 2.177

MIN RADIUS: 0.124

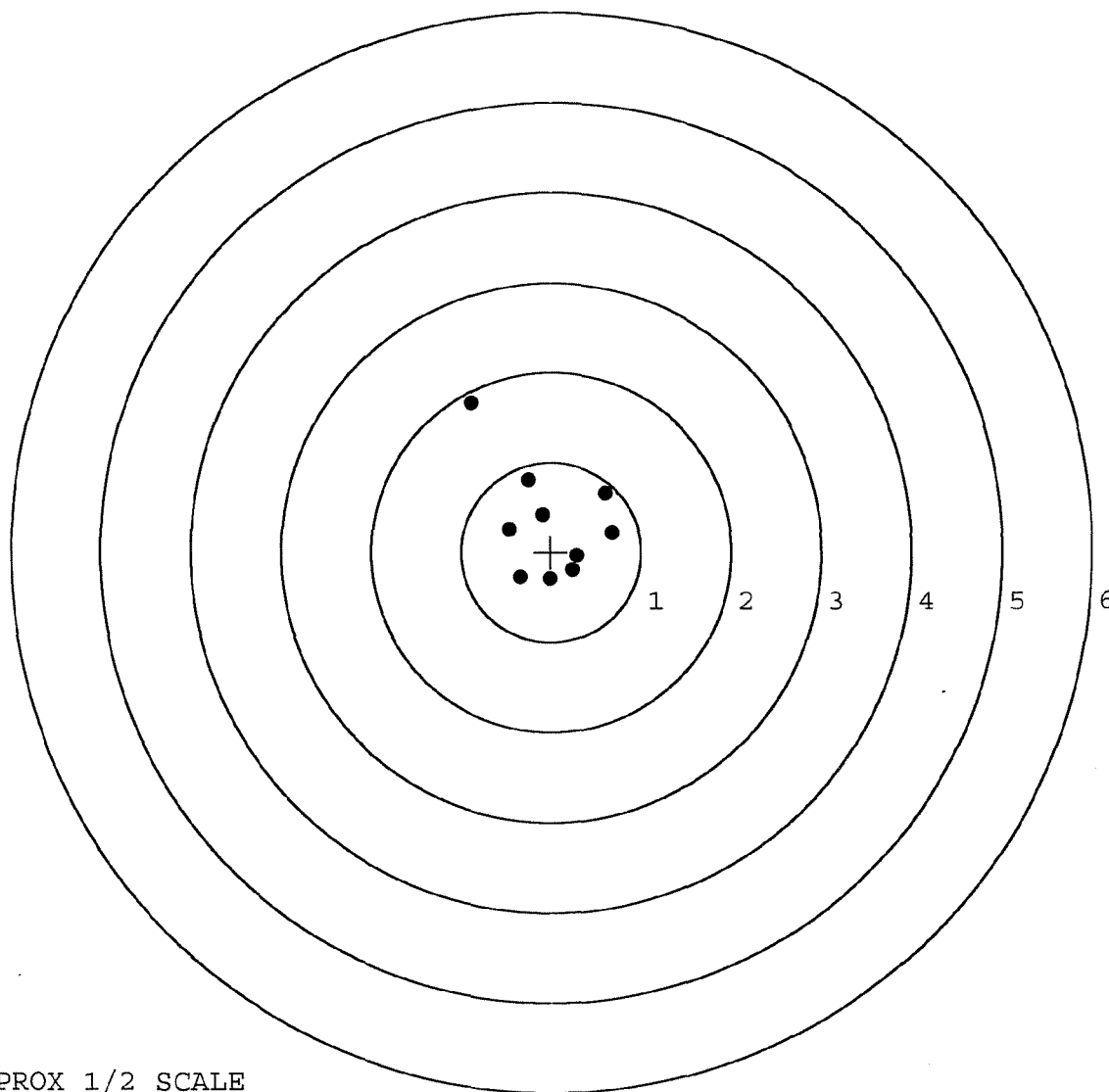
MAX RADIUS: 1.593

MEAN RADIUS: 0.650

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410230. __0

TARGET NUMBER: 2

FILE DATE: 10/04/2004

FILE TIME: 08:08

POINT#	X	Y
1:	0.975	-0.903
2:	1.009	-0.214
3:	-0.032	-1.149
4:	-0.101	-1.416
5:	-0.424	-0.962
6:	-0.311	0.068
7:	0.477	0.615
8:	0.216	0.689
9:	-0.112	0.649
10:	-0.910	0.483

X CENTROID: 0.079

Y CENTROID: -0.214

POA TO CENTROID: 0.228

HORZ SPREAD: 1.919

VERT SPREAD: 2.105

GROUP SPREAD: 2.129

MIN RADIUS: 0.481

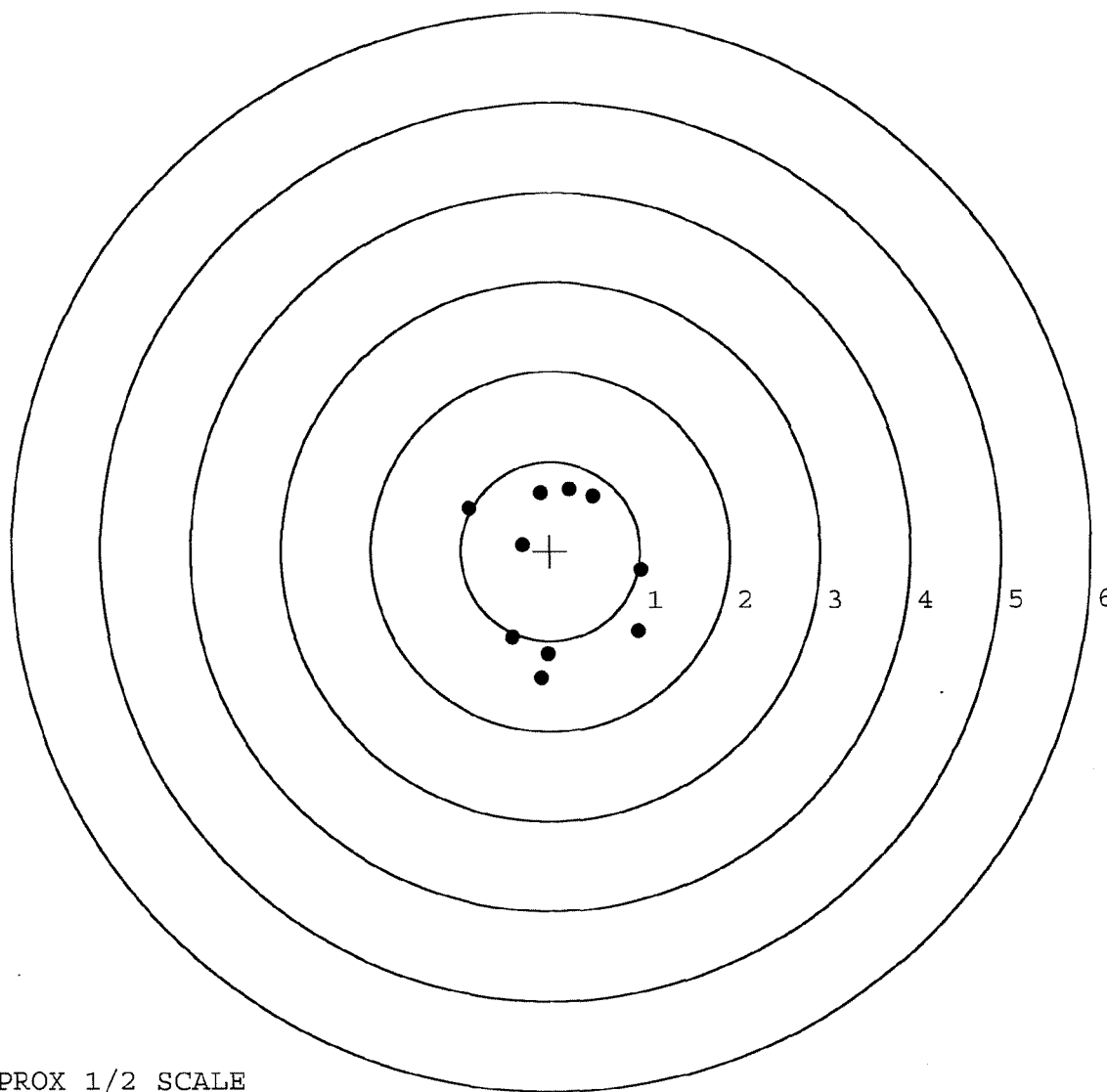
MAX RADIUS: 1.215

MEAN RADIUS: 0.953

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

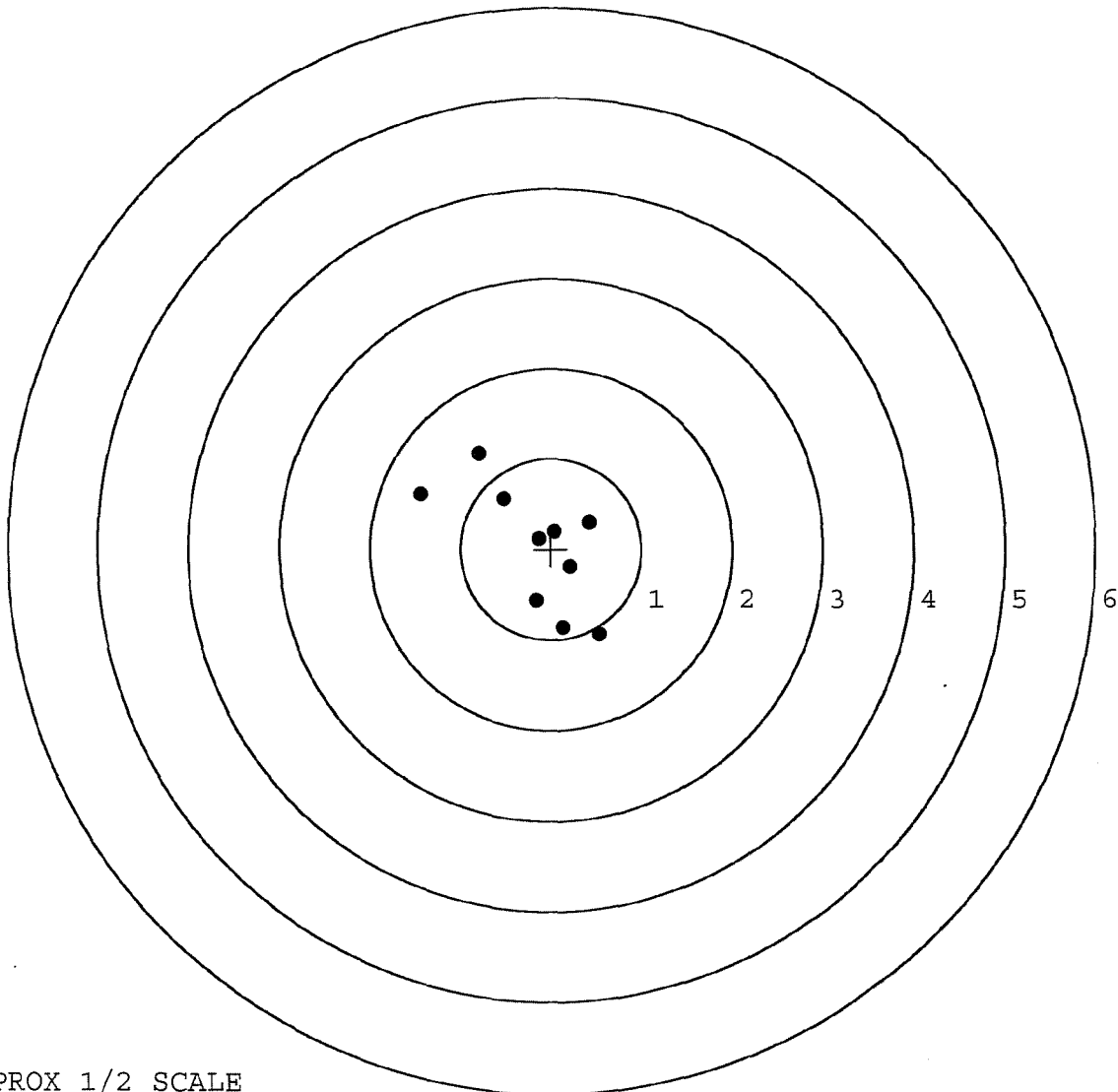


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410230. __0
TARGET NUMBER: 3
FILE DATE: 10/04/2004
FILE TIME: 08:08

X CENTROID: -0.170
Y CENTROID: 0.024
POA TO CENTROID: 0.172
HORZ SPREAD: 1.979
VERT SPREAD: 1.989
GROUP SPREAD: 2.509
MIN RADIUS: 0.096
MAX RADIUS: 1.395
MEAN RADIUS: 0.745
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.539	-0.940
2:	0.135	-0.871
3:	-0.162	-0.568
4:	0.218	-0.197
5:	0.426	0.295
6:	0.044	0.199
7:	-0.135	0.114
8:	-0.524	0.558
9:	-0.804	1.049
10:	-1.440	0.603



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410230. 0

TARGET NUMBER: 4

FILE DATE: 10/04/2004

FILE TIME: 08:08

X CENTROID: 0.205

Y CENTROID: -0.200

POA TO CENTROID: 0.286

HORZ SPREAD: 2.103

VERT SPREAD: 3.071

GROUP SPREAD: 3.547

MIN RADIUS: 0.245

MAX RADIUS: 1.824

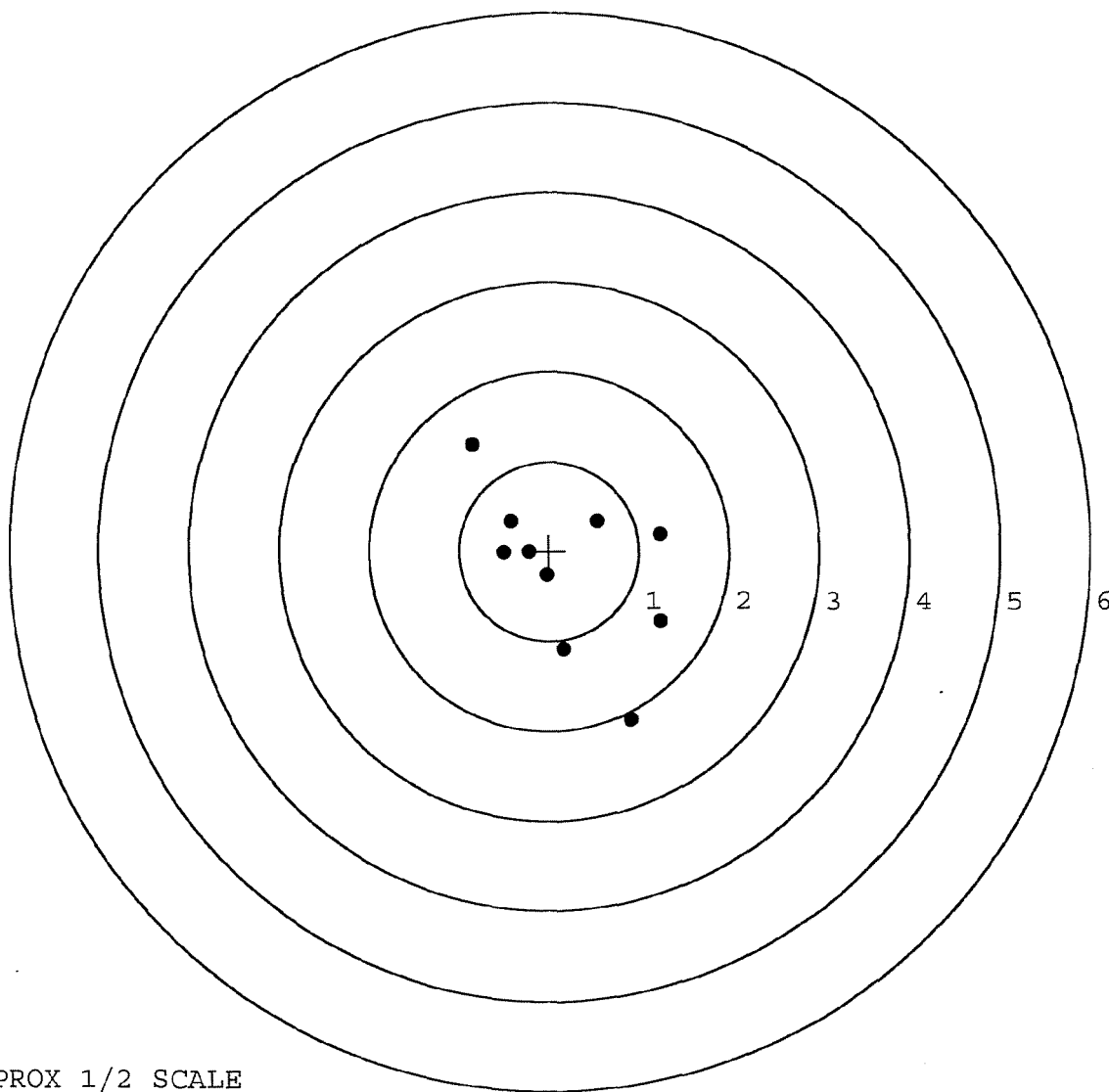
MEAN RADIUS: 0.968

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.244	-0.783
2:	0.916	-1.879
3:	0.164	-1.097
4:	1.237	0.188
5:	0.537	0.335
6:	-0.859	1.192
7:	-0.433	0.339
8:	-0.506	-0.014
9:	-0.221	-0.007
10:	-0.030	-0.270



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410230. 0

TARGET NUMBER: 5

FILE DATE: 10/04/2004

FILE TIME: 08:08

POINT#	X	Y
1:	0.160	-1.703
2:	0.446	-0.584
3:	0.713	0.022
4:	-0.117	0.439
5:	-0.244	0.749
6:	-0.120	1.010
7:	-0.703	0.239
8:	-0.637	-1.264
9:	-0.849	-1.209
10:	-1.110	-1.349

X CENTROID: -0.246

Y CENTROID: -0.365

POA TO CENTROID: 0.440

HORZ SPREAD: 1.823

VERT SPREAD: 2.713

GROUP SPREAD: 2.727

MIN RADIUS: 0.726

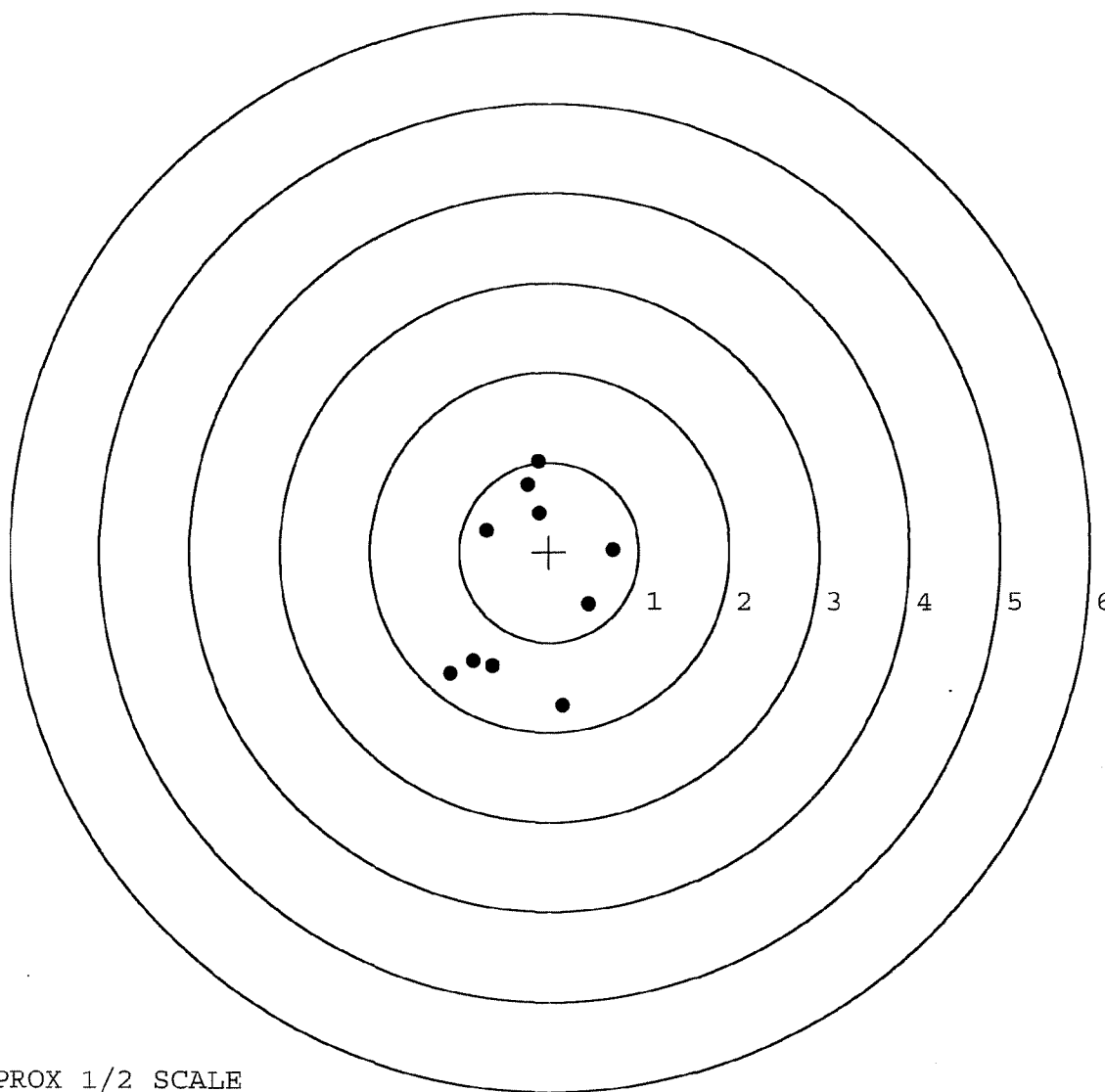
MAX RADIUS: 1.398

MEAN RADIUS: 1.055

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE